

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010034**Date Inspected:** 10-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin and Wu Zhi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions in the trial assembly yard. Locations and description of work are as followed:

5CW

1. Repair work (dressing weld profile with hand held grinder) on the edge plate to edge plate weld seam. Location of noted work is on the cross beam and counter weight side of segment.

6AE + 6BE

2. Noted various side plate t stiffeners to t stiffener on counter weight side of segment has excessive gap (approximately between 15mm ~20mm) opening on weld joint.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

6BE

3. Noted small longitudinal diaphragm that connects to panel point 41 on bike path side of segment, was removed for buildup of end. (Welding was not performed at this time)

1BW+1AW

4. Noted area sample was removed for testing on weld joint OBW1A-003 root pass was performed (previous work shift). This QA Inspector noted weld joint was filled with water and leaking from opposite side of plate. (Backing bar side of weld joint).

This QA Inspector performed MT in excavation area and observed one (1) MT longitudinal indication observed (approximately 12mm in length).

2. Observed ABF representatives Peter Ferguson, Steven Lawton and Kevin Chen measuring sample to be removed o weld joint OBW1A-008. Y location is between 3665~3965mm. Length of cut sample is 300mm by 25mm and will be sent for the required testing.

NDT Observation

QA Inspector observed ABF's personnel performing Ultra Sonic (UT) inspection on repair areas. Locations and description of work are as followed:

1. Side plate repair weld located at y location 6500 on the cross beam side of segment 1AW + 1BW.

This QA Inspector observed ZPMC Magnetic Particle (MT) Technician performing MT on various locations in the trial assembly yard. Locations are as followed:

1AAW+1AW

1. Weld build up on deck plate stiffeners located on counter weight side of segment per repair procedure CWR778 (Rev 1) and RFI 1904.

Note:

Due to inclement weather, work was limited in the OBG Trail Assembly Yard on today's work shift.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
----------------------	------------	-----------------------------

Reviewed By:	Carreon,Albert	QA Reviewer
---------------------	----------------	-------------